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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2121
Job Sheet 170755



Part No: D2121

Job Qty: 20 ea

Part Name: Clamp Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/19/18

Job Tracking No:

Due Date: 2/9/18

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV D IPP: D 04.05.27 Added Step 2-3; changed Step 4 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	20 Ea		2/8/18	0.00	0.00	Start Up Large Fab-1		IBC
100	Large Fab	20 pcs		2/8/18	0.00	7.09	Large Fab 1		JAL
110	QC	20 pcs		2/8/18	0.00	0.00	QC9		PD 18-04-21
120	Small Fab	20 pcs		2/9/18	0.00	14.49	Small Fab-1		FP DAS 36
130	QC	20 pcs		2/9/18	0.00	0.00	QC5		SPC
140	Packaging	20 pcs		2/9/18	0.00	0.00	Packaging3-1		
150	QC21-SA	20 Ea		2/9/18	0.00	0.00	QC21		DAS 21 2-20

Part Op 100 - Weld washer & wing nut as per Dwg D2121 & QSI 004 Identify as Wing Nut assembly
Descriptions: 120 - Assemble parts from steps 5-14 and Wing Nut Assembly as per Dwg D2121. Drill and deburr hole in coupling nut as per Dwg D2121. (Note: Install MS21042L4 Nut loosely) Cut D2771-BCFC-025-150 at 1.500"

FEB 12 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
5/16-18 SS WING NUT	Wing Nut	20 Ea (1 ea)	90-Start up Operation	M110084 x 20
5/16WC	Washer FM137770X11	20 Ea (1 ea)	90-Start up Operation	5006224 x 9
5/16-18 SS JAM NUT	GA Jam Nut M110084-298	20 Ea (1 ea)	120-Small Fab	
5/16-18 SS THREADED	BA Threaded Rod 6.5" long	20 ft (1 ea)	120-Small Fab	5006222
5/16-18SS1COUPLING *	GA Coupling Nut M130477-299	20 Ea (1 ea) (3)	120-Small Fab	5040334 (17)
AN4-4A	346 Bolt 5019363	20 Ea (1 ea)	120-Small Fab	
D2012-107	GA Clevis 5030569 (18)	20 Ea (1 ea)	120-Small Fab	5037678 (2)
D2529	008 Washer 5019348	100 Ea (5 ea)	120-Small Fab	
D2771-BCFC-025-150	GA Bolt 5018578	20 Ea (1 ea)	120-Small Fab	
D2771-LCC-025	GA Lock Nut B8493 (18)	20 Ea (1 ea)	120-Small Fab	
MS21042L4	303 Nut 5016351	20 Ea (1 ea)	120-Small Fab	
NAS1149D0463J	263 Washer 5014733	20 Ea (1 ea)	120-Small Fab	

Part Specifications

Specifications could not be found.

5/16-18SS THREADED: 5006223 (11)
5006222 (9)
5/16-18SS1COUPLING: 5036185 (17)

Plex 1/19/18 10:07 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: Part No NCR No Date : 	DISPOSITION Start up Operation 01/26/18 Job No: 170755	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 25%;">Skid-tube ☐</td> <td style="width: 25%;">Cross tube ☐</td> <td style="width: 25%;">Water Jet ☐</td> <td style="width: 25%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐															
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		Disposition 	Completed By 																														
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		QC / QA Coordinator Approval																															
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL: 1 613 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com S035994 Clamp Assembly		FAULT CATEGORY <table style="width: 100%; border-collapse: collapse;"> <tr> <td style="width: 33%;">Temperature/Cure ☐</td> <td style="width: 33%;">Power Loss/Surge ☐</td> <td style="width: 33%;">Positioned Wrong ☐</td> </tr> <tr> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>		Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Countersink ☐	Off-set ☐	Drawing ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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PART NO: D2121 Original Serial #: S035994 Revision: Operation: Change No:																																	
Substation ☐ Process Improvement ☐ Marks/Chatter ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐ OTHER : _____																																	